



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2805-2

Job Sheet 188638



Part No: D2805-2

Job Qty: 10 pcs

Part Name: Stop



Part Weight: 0 lbs

Job Created: 1/14/19

Due Date: 1/25/19

Type: SOLD

Status: New

Priority: Medium

Job Tracking No:

Created By: Marie Lajeunesse

Description:

Note: DWG REV B IPP: B 00.11.14 Revised Finishing step to Acid etch and Alodine EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	10 pcs		1/25/19	0.00	0.13	Bandsaw - 1		Bm
110	HAAS 4 Axis - B4B	10 pcs		1/25/19	0.16	3.25	HAAS - 1 - B4B	DAS	19/01/25
							HAAS - 2 - B4B	52	
							HAAS - 3 - B4B	9.89	
							HAAS - 4 - B4B		
130	QC 8	10 pcs		1/25/19	0.00	0.00	QC 8 - 12		mmc 14/01/25
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 38		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		D.R 19/01/28
							QC 8 - 9		
							QC 8 - 68		
140	Handfinish - 1-1 Chemical-B4B	10 pcs		1/25/19	0.00	0.38	Handfinish - 1 - 1 - B4B		
							Handfinish - 1 - 2 - B4B		
							Handfinish - 1 - 3 - B4B		
							Handfinish - 1 - 4 - B4B		
							Handfinish - 1 - 5 - B4B		
							Handfinish - 1 - 6 - B4B		
							Handfinish - 1 - 7 - B4B		
							Handfinish - 1 - 8 - B4B		

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ Skid-tube ☐		DEPARTMENT/PROCESS Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐ Quality ☐			
Date : _____		Disposition				MRB (QSI042)	
Description Work						Completed By	
						Lead hand / Supervisor	
						QC / QA Coordinator	
Root Cause		ILT CATEGORY					
Operator ☐		Power Loss/Surge ☐					
Manufacturing Process ☐		Folio/Program ☐					
Equip/Tooling ☐		Grain Direction ☐					
Handling/Presservation ☐		Weld ☐					
Material ☐		Wrong Stock Pulled ☐					
Product Improvement ☐		Out of Sequence ☐					
Process Improvement ☐		Off-set/Set-up ☐					
Human Factors ☐		Positioned Wrong ☐					
		Outside Tolerance ☐					
		Drawing ☐					
		Finish ☐					
		Part Lost/Missing ☐					
		Misread ☐					

Container No: S147933
Part: D2805-2
Job No: 188638
Serial No/Batch: S147933
Revision: _____
Inspector: _____
Exp Date: _____
Instructions: Various STC's
Date: 01/25/19
Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 832-6200
Email: sales@dartaero.com
www.dartaerospace.com

					Handfinish - 1 - 9 - B4B
					Handfinish - 1 - 10 - B4B
					Handfinish - 1 - 11 - B4B
					Handfinish - 1 - 12 - B4B
					Handfinish - 1 - 13 - B4B
					Handfinish - 1 - 14 - B4B
					Handfinish - 1 - 15 - B4B
					Handfinish - 1 - 16 - B4B
					Handfinish - 1 - 17 - B4B
					Handfinish - 1 - 18 - B4B
					Handfinish - 1 - 19 - B4B
					Handfinish - 1 - 20 - B4B
					Handfinish - 1 - 21 - B4B
					2Handfinish - 1 - 22 - B4B
150	QC 3	10 pcs	1/25/19	0.00 0.00	QC 3 - 10
					QC 3 - 13
					QC 3 - 15
					QC 3 - 17
					QC 3 - 18
					QC 3 - 2
					QC 3 - 26
					QC 3 - 28
					QC 3 - 3
					QC 3 - 30
					QC 3 - 34
					QC 3 - 36
					QC 3 - 38
					QC 3 - 41
					QC 3 - 51
					QC 3 - 58
					QC 3 - 59
					QC 3 - 6
					QC 3 - 68
					QC 3 - 9
160	Packaging 3-1 - Stock - B4B	10 pcs	1/25/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
170	QC 21 - SA	10 pcs	1/25/19	0.00 0.00	QC 21 - SA - 21
Part Op 100 - (Bandsaw) Cut Bar: 3.150" Long +0.010/-0.030" Descriptions: 110 - (HAAS CNC Vertical Machine) 1- Machine as per Folio FA104 and Dwg D2805 Identify as D2805-2 130 - (QC8- Inspect parts - second check) 140 - (Chemical Conversion Coat per QSI005 4.1) 150 - (QC3- Inspect Part Finish) 160 - (Identify as per dwg & Stock Location: _____) LOCATION : GA 170 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M6061T6B1.500X1.500	6061-T6 Bar 1.50 X 1.50	2.6250 ft (.2625 ea)	100-Bandsaw - 1	5033 413	

DAS
38
9-89

DAS
28
9-89

DAS
21
9-89

JAN 30 2019

MATT.
USED
2-635

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B1.500X1.500	3	29	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Stop	2.974inches ± 0.010	2.984 2.964	2.974	
2	Stop	0.240inches ± 0.010	0.250 0.230	0.240	
3	Stop	0.100inches ± 0.010	0.110 0.090	0.100	
4	Stop	1.420inches ± 0.001	1.421 1.419	1.421	
5	Stop	1.125inches ± 0.010	1.135 1.115	1.125	
6	Stop	0.250inches + 0.005 - 0.000	0.255 0.250	0.252	
7	Stop	0.250inches ± 0.010	0.260 0.240	0.250	
8	Stop	1.500inches ± 0.010	1.510 1.490	1.496	
9	Stop	1.000inches ± 0.010	1.010 0.990	1.000	
10	Stop	0.875inches + 0.001 - 0.000	0.876 0.875	0.875	

Plex 1/14/19 7:41 AM Dart.lajeunesse.marie

AS
12
-89

19/01/25

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
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Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					